

Work Order ID 117834 -1 **SPLIT**
May-23-14 10:12:39 AM

117834

Page 1

Item ID: D3049-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 5/05/14 Start Qty: 12.00 ***12*** 2 Cust Item ID:
Required Date: 5/05/14 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1								

105

0.00

105

Purchasing

Purchasing

Memo

0.00

ISSUE PO

24350

CUT BLANK AS PER FILE D3049-1_BLANK

C214/05/26 12

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

12x SP14-6-10

118

QC6- Inspect dimensions to drawing

0.00

118

QC

Quality Control

Memo

0.00

DAS

27

9-89

14/6/12

12

Work Order ID 117834

117834

Page 2

May-23-14 10:12:39 AM

Item ID: D3049-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 5/05/14 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1 3-Deburr	0.00 0.00				DAS 02 9-89		ET 14-06-12 (x2)	
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				DAS 02 9-89		ET 14-06-12	
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				DAS 27 9-89 4/6/12		2	

Work Order ID 117834

May-23-14 10:12:39 AM

117834

Page 3

Item ID: D3049-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 5/05/14 Start Qty: 12.00 *12*

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 12.00 *12*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo	0.00 0.00				2x	DAS 28 9-59	JUN 12 2014	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MLJ 140612

14.6-12

Picklist Print

May-23-14 10:12:39 AM

Page 1

Work Order ID: 117834

117834

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	400.0000	3.4	41			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CL 14/05/28

Location

Loc Qty

Loc Code

MAT018

400

m128267

47

m128668

353

m129293

DART AEROSPACE LTD		Work Order:	117834
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø0.260	+0.005/-0.000	0.260	✓		vern	ET-4
B 0.93	+/-0.030	0.931	✓			
C 0.40	+0.030/-0.000	0.403	✓			
D 2.00	+/-0.030	2.001	✓			
E 10.250	+/-0.010	10.250	✓		Tape	ET-10
F 4.540	+/-0.030	4.546	✓			
G 5.88	+/-0.030	5.880	✓			
H 0.38	+/-0.030	0.386	✓			
I 11.50	+/-0.030	11.500	✓			
J 0.07 x 45°	+0.030/-0.010	0.060	✓			
K 0.44 - 0.47	+/-0.000	0.449	✓			
L R0.25	+/-0.030	0.280	✓			
M 0.38	+/-0.010	0.390	✓			
N 0.95	+0.030/-0.010	0.962	✓			
O 0.69	+/-0.030	0.682	✓			
P 0.20	+/-0.030	0.203	✓		depth gauge	ET-06
Q 23.00	+/-0.030	23.000	✓			
R 0.25 x 45°	+/-0.030	0.234	✓			

Measured by: DAS 02 ET	Audited by: SP	Prototype Approval:	N/A
Date: 9-89 14-06-12	Date: 14/6/12	Date:	N/A

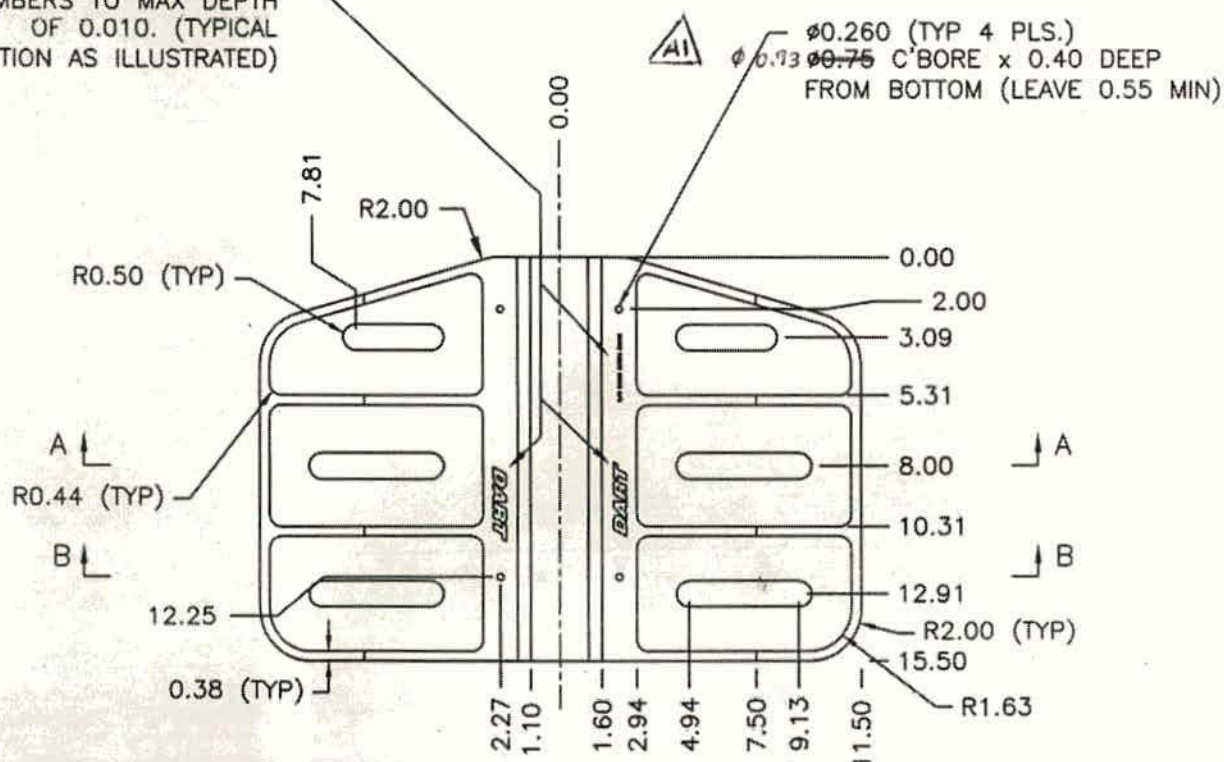
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	03.01.13	φ 0.93 WAS φ 0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

NO. 117834M5
140508
STAMP
REMARKS
DATE
BY
CHECKED
DATE
BY

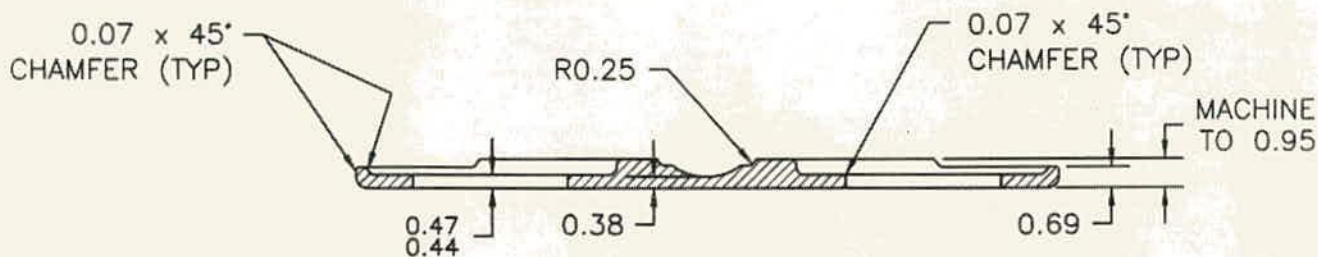
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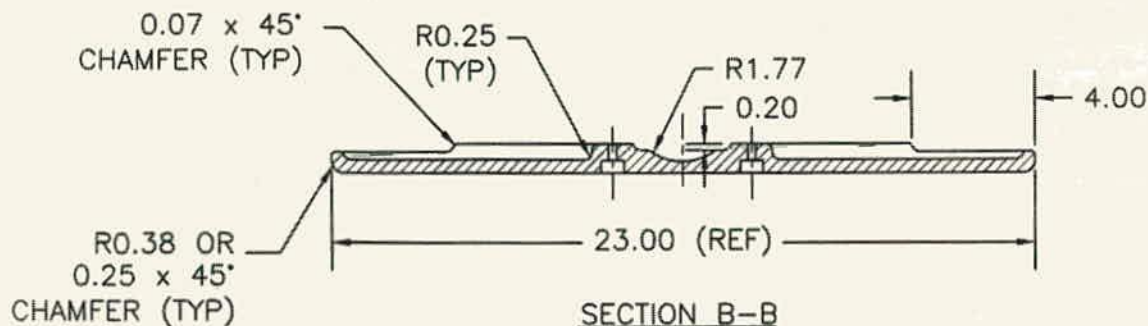


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 [Signature]



SECTION A-A



SECTION B-B

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Dart Aerospace Ltd,
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24350**

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 3 of 4

Order From :

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

VC-TPI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via: Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

7	117863	D2916-3 CABLE GUARD	6/13/2014 Yes 6/13/2014	8.00	✓	\$24.80	\$198.
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CUT BLANK AS PER FILE

Line Total: ~~\$198.~~

8	117834	D3049-1 BEARPAW	6/13/2014 Yes 6/13/2014	12.00	✓	\$33.30	\$399.
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CUT BLANK AS PER FILE

Line Total: \$399.

9	116954	D3075-1 BEARPAW	6/13/2014 Yes 6/13/2014	12.00	✓	\$18.37	\$220.
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CUT BLANK AS PER FILE

Line Total: \$220.

SP14-6-10

Note:

5/26/2014